



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D350-591-122
Job Sheet 175975



Part No: D350-591-122

Job Qty: 4 ea

Part Name: Heli-Access-Step™ RH - High Gear, Short Step, Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/13/18

Job Tracking No:

Due Date: 5/23/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D2351-042 REV E, IIN-D350-591 REV H IPP Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		5/22/18	0.00	0.00	Start Up Large Fab-4		DC 2018-01-25
110	Large Fab	4 pcs		5/22/18	0.00	3.20	Large Fab 8		DC 2018-01-25
120	CNC Bend Skid tubes	4 pcs		5/22/18	0.38	1.38	CNC Bend Skid tube		THW DAS
122	QC	4 pcs		5/22/18	0.00	0.00	QC5		38
126	Large Fab	4 pcs		5/22/18	0.00	4.49	Large Fab 8		SLY 9-89
130	QC	4 pcs		5/22/18	0.00	0.00	QC5		CPL
140	Large Fab	4 pcs		5/22/18	0.00	3.33	Large Fab 2		CPL
150	QC	4 pcs		5/22/18	0.00	0.00	QC9		CPL
160	QC	4 pcs		5/22/18	0.00	0.00	QC5		CPL
170	HandFinish	4 pcs		5/22/18	0.00	0.92	HandFinish1		SA 18-05-08
180	QC	4 pcs		5/22/18	0.00	0.00	QC7-2		CPL
190	Large Fab	4 pcs		5/22/18	0.00	3.20	Large Fab 2		DC 2018-05-22
220	QC	4 pcs		5/22/18	0.00	0.00	QC10		CPL
230	QC	4 pcs		5/22/18	0.00	0.00	QC5		CPL
240	HandFinish	4 pcs		5/22/18	0.00	0.75	HandFinish1		SA 18-05-23
250	Powdercoat	4 pcs		5/22/18	0.00	0.83	Powdercoat1		BR 18-5-28
260	HandFinish	4 pcs		5/23/18	0.00	0.75	HandFinish3		BE 18-05-24
270	QC	4 pcs		5/23/18	0.00	0.00	QC3		38
280	Packaging	4 pcs		5/23/18	0.00	0.00	Packaging1-3		MAY 29 2018
290	QC	4 pcs		5/23/18	0.00	0.00	QC4		SMI
295	DC	4 pcs		5/23/18	0.00	0.00	DC		SMI
300	Packaging	4 pcs		5/23/18	0.00	0.00	Packaging3-1		SMI
310	QC21-FG	4 Ea		5/23/18	0.00	0.00	QC21		SMI

Part Op 110 - 1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

Descriptions: 120 - Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041

126 - ***BUFF AND REMOVE BENDING MARKS WITHIN .005", if deeper see engineer***

140 - 1-Bevel Fwd and Aft end for welding

190 - 1-Rivet Leg Assembly as per Dwg D2351

250 - START TIME: 3:25 O.V.T. 3:00 FINISH: 3:05

295 - Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

300 - Identify and pack for shipping as per PPP D350-591-121

310 - 3-Do not Grind top edge Flush

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	2 Ea (.5 ea)	90-Start up Operation	SO14552
D2850-2	End Cap	4 Ea (1 ea)	126-Large Fab	SO63804
D2582	Hi-Skid Step Leg Assembly	4 Ea (1 ea)	190-Large Fab	SO72948
D2673-34	End Plate	4 Ea (1 ea)	190-Large Fab	SO63804
MS20600-AD4W3	Cherry Rivet	64 Ea (16 ea)	190-Large Fab	SO63804 SO62619
AN3-37A	Bolt	8 Ea (2 ea)	280-Packaging	
AN4-13A	Bolt	4 Ea (1 ea)	280-Packaging	
AN4-16A	Bolt	8 Ea (2 ea)	280-Packaging	
D2230-1	Mounting Lug	4 Ea (1 ea)	280-Packaging	
D2230-3	Mounting Lug	4 Ea (1 ea)	280-Packaging	
D2732-030	Rubber Cushion - 3"	8 Ea (2 ea)	280-Packaging	
MS21042L3	Nut	8 Ea (2 ea)	280-Packaging	
MS21042L4	Nut	12 Ea (3 ea)	280-Packaging	
NAS1149D0363J	Washer	16 Ea (4 ea)	280-Packaging	
NAS1149D0463J	Washer	24 Ea (6 ea)	280-Packaging	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	2	152	0
126-Large Fab	D2850-2	4	5	0
190-Large Fab	D2582	4	1	0
	D2673-34	4	21	0
	MS20600-AD4W3	64	393	0
280-Packaging	AN3-37A	8	90	0
	AN4-13A	4	712	0
	AN4-16A	8	312	0
	D2230-1	4	36	0
	D2230-3	4	71	0
	D2732-030	8	353	0
	MS21042L3	8	2,448	0
	MS21042L4	12	3,323	0
	NAS1149D0363J	16	2,782	0
	NAS1149D0463J	24	5,063	0

Part Specifications

Specifications could not be found.

Plex 4/13/18 8:07 AM Dart.Gagnon.Michelle

SO65030x4



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Container No: S065030



Part: D350-591-122

Job No: 175975

Serial No/Batch: S065030

Revision:

Inspector:

Date: 04/25/18



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003366	S073779	AN3-37A	Bolt	s041154	ST347	8
003366	S073778	AN4-13A	Bolt	s054119	ST344	4
003366	S073777	AN4-16A	Bolt	s068654	ST343	8
003366	S073776	D2230-1	Mounting Lug	S065883	ST521	4
003366	S073775	D2230-3	Mounting Lug	S066272	ST521	4
003366	S073755	D2732-030	Rubber Cushion - 3"	S059609	ST410	8
003366	S073741	MS21042L3	Nut	s054107	ST303	8
003366	S073738	MS21042L4	Nut	s056039	ST303	12
003366	S073734	NAS1149D0363J	Washer	s015269	ST263	16
003366	S073729	NAS1149D0463J	Washer	s055952	ST263	24

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 5/25/18 9:29 AM dart.quirion.sonia

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hel-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hel-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hel-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hel-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hel-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT